

JUN 01 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-708-011
Job Sheet 173558-A



Part No: D205-708-011

Job Qty: 1 ea

Part Name: Adjustable Engine Modification



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/22/18

Job Tracking No:

Due Date: 3/22/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV C IPP C 06.01.31 Added MS206136C12 JLM/AP IPP Rev:D 07-12-12 as per ECN 1074 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	QC	1 pcs		3/22/18	0.00	0.00	QC5		15-05-23
135	Packaging	1 pcs		3/22/18	0.00	0.00	Packaging1-2		
140	QC	1 pcs		3/22/18	0.00	0.00	QC4		hls DAS
150	Packaging	1 pcs		3/22/18	0.00	0.00	Packaging3-1		28
155	DC	1 pcs		3/22/18	0.00	0.00	DC		1-89
160	QC21-FG	1 Ea		3/22/18	0.00	0.00	QC21		

Part Op 130 - Inspect assembly. Visually inspect thread, fit and cad plating

Descriptions: 150 - Identify and pack for shipping as per PPP D205-708-011 Location: FG028

155 - Photocopy bluefile and create labels per PPP D205-708-011, CHG001

JUN 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3284-009	Bearing	6 Ea (6 ea)	135-Packaging	5073127
D3284-011	Bearing	1 Ea (1 ea)	135-Packaging	5046501
MS20613-6C12	Rivet	2 Ea (2 ea)	135-Packaging	FM136648-0
MS20613-6C16	Rivet	8 Ea (8 ea)	135-Packaging	FM136648-0
MS20613-6C18	Rivet	4 Ea (4 ea)	135-Packaging	FM136648-0
MS20613-6C19	Rivet	12 Ea (12 ea)	135-Packaging	FM136837

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
135-Packaging	D3284-009	6	14	0
	D3284-011	1	6	0
	MS20613-6C12	2	75	0
	MS20613-6C16	8	194	0
	MS20613-6C18	4	40	0
	MS20613-6C19	12	89	0

Part Specifications

Specifications could not be found.

Plex 5/22/18 3:28 PM dart.leroux.jason

mid 19 June 2019

DQA:

Date:

QA Closed

Date:

JUN 19 2019

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: <u>173558-A</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. <u>D205-708-011</u>		Rework ☒	Scrap ☐	Skid-tube Machining ☐	Cross tube Small Fab ☐
NCR No. <u>19-7184</u>		Use-as-is ☐	Suspected Unapproved ☐	Thermoforming Large Fab ☐	Finishing Composite ☐
Date: <u>18-05-23</u>	Step #: <u>130</u>	QTY Effective: <u>1</u>		Disposition <u>①</u>	
Description Work Order Deviation		Return qty 2 WASS09-12 from PO039230 to supplier and request for credit			
Qty of 2 nuts WASS09-12 did not thread on stud D3284-007 (B80705-1)		Pull qty 2 WASS09-12 from stock and install on stud B# 15057 15057			
Root Cause		FAULT CATEGORY			
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved
Internal Transport	Poor Information	Crushing	Heat Treat	Off-set	Drawing
Tribal Knowledge	Rushing	Wave/Twist in Tube	Wave/Twist in Tube	Mislabeled	Finish
LOA	Product Improvement	Wave/Twist in Tube	Wave/Twist in Tube	Fit/Function	Misread
Substation	Process Improvement	Wave/Twist in Tube	Wave/Twist in Tube	Misaligned/off center	Turning Sequence
Past Expiry Date	Manufacturing Process	Wave/Twist in Tube	Wave/Twist in Tube		
Misidentified	Past Due	Wave/Twist in Tube	Wave/Twist in Tube		
OTHER:					

Completed By 11 MAY 24 2019
9-89
Lead hand / Supervisor Approval Verification

QC / QA Coordinator Approval

PD 18.05.23



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Tel (613) 632-5200

Ref only.

D205-708-011
Job Sheet 173558



Part No: D205-708-011

Job Qty: 1 ea

Part Name: Adjustable Engine Modification



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/5/18

Job Tracking No:

Created By: Chantal Lavoie

Due Date: 3/22/18

Description:

Type: Stock

Note: DWG REV C IPP C 06.01.31 Added MS206136C12 JLM/AP IPP Rev:D 07-12-12 as per ECN 1074 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Purchasing	2 pcs		3/22/18	0.00	0.00	Purchasing		ATC 18/05/18
120	Packaging	2 pcs		3/22/18	0.00	0.00	Packaging2		ATC 18/05/18
130	QC	2 pcs		3/22/18	0.00	0.00	QC5		MAY 27 2018
135	Packaging	2 pcs		3/22/18	0.00	0.00	Packaging1-2		9-89
140	QC	2 pcs		3/22/18	0.00	0.00	QC4		
145	DC	2 pcs		3/22/18	0.00	0.00	DC		
150	Packaging	2 pcs		3/22/18	0.00	0.00	Packaging3-1		
160	QC21-FG	2 Ea		3/22/18	0.00	0.00	QC21		

Part Op 90 - Issue P/O: *P/O 039230* for: (ATTN:ORDER THE B P/N'S! - SAME AS BOM) 6 D3284-001 (B80702-1) Sleeve
 Descriptions: 2 D3284-003 (B80703-1) Stud 4 D3284-005 (B80704-1) Stud 6 D3284-007 (B80705-1) Stud 6 NAS509-12 Nut 6
 NAS509L12 Nut Stud To be assembled as per Dwg B80701 Rev. C Possible Supplier: Northern Aero Certificate of
 Conformity is required
 120 - Receive & Inspect For Transit Damage Ensure Certificate of Conformity is attached
 130 - Inspect assembly. Visually inspect thread, fit and cad plating
 145 - Photocopy bluefile and create labels per PPP D205-708-011, CHG001
 150 - Identify and pack for shipping as per PPP D205-708-011 Location: FG028

MAR 07 2018

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
B80702-1	Sleeve	12 pcs (6 ea)	90-Purchasing	5072702
B80703-1	Stud	4 pcs (2 ea)	90-Purchasing	5072703
B80704-1	Stud	8 pcs (4 ea)	90-Purchasing	5072704
B80705-1	Stud	12 pcs (6 ea)	90-Purchasing	5072705
D3284-009	Bearing	12 Ea (6 ea)	90-Purchasing	
D3284-011	Bearing	2 Ea (1 ea)	90-Purchasing	
MS20613-6C12	Rivet	4 Ea (2 ea)	90-Purchasing	
MS20613-6C16	Rivet	16 Ea (8 ea)	90-Purchasing	
MS20613-6C18	Rivet	8 Ea (4 ea)	90-Purchasing	
MS20613-6C19	Rivet	24 Ea (12 ea)	90-Purchasing	
NAS509-12	Nut	12 Ea (6 ea)	90-Purchasing	5072706
NAS509L12	Nut	12 Ea (6 ea)	90-Purchasing	5072707

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	B80702-1	12	0	0
	B80703-1	4	0	0
	B80704-1	8	0	0
	B80705-1	12	0	0
	D3284-009	12	6	0
	D3284-011	2	4	0
	MS20613-6C12	4	75	0
	MS20613-6C16	16	194	0
	MS20613-6C18	8	40	0
	MS20613-6C19	24	95	0
	NAS509-12	12	62	0
	NAS509L12	12	46	0
Part Specifications				
Specifications could not be found.				

Plex 3/5/18 8:12 AM dart.lavoie.chantal

SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
6 D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
2 D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
4 D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
6 D3284-007 STUD	ACS P/N <u>B80705-1</u> PER ACS DWG B80705 REV. B
6 D3284-009 BEARING	BHT P/N 47-140-252-5
1 D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708

x10 5
 x4 2
 x8 4
 x10 5



NOTE:
 FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/-003/-005/-007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH
 MIN Ft_u = 90 Ksi
 MIN Ft_y = 70 Ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

RELEASED

2010-03-25

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. B	
MFG. APPR.	<i>[Signature]</i>	D3284 SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE SCALE	
DE APPR.	<i>[Signature]</i>	ADJUSTABLE ENGINE MOUNT NTS	
DATE	09.07.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039230

Supplier: BEA001-VU
B/E Aerospace
25 Dunlop Avenue
Winnipeg,
MB
R2X 2V2 Canada
Phone: 204-772-9922
Fax: 204-772-7568

PO No: PO039230
PO Date: 3/7/18
Due Date: 3/27/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

REVISED

E-MAILED
MAR 08 2018

MAR 08 2018

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	B80702-1			Sleeve	Firmed	4/24/18	12 pcs	0 pcs	12 pcs	\$250.00/pcs	\$3,000.00
2	B80703-1			Stud	Firmed	4/30/18	4 pcs	0 pcs	4 pcs	\$99.00/pcs	\$396.00
3	B80704-1			Stud	Firmed	4/30/18	8 pcs	0 pcs	8 pcs	\$165.00/pcs	\$1,320.00
4	B80705-1			Stud	Firmed	4/30/18	12 pcs	0 pcs	12 pcs	\$170.00/pcs	\$2,040.00
5	NAS509-12			Nut receive ea	Firmed	4/30/18	12 Ea	0 Ea	12 Ea	\$12.00/Ea	\$144.00
6	NAS509L12			Nut receive ea	Firmed	4/30/18	12 Ea	0 Ea	12 Ea	\$12.00/Ea	\$144.00
Grand Total:										\$7,044.00	

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A032 PUBLIC LAW 101-592 FASTENER QUALITY ACT
A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/8/18 12:33 PM dart.lavoie.chantal



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Power to Deliver.

Page 1 of 1

Certificate of Compliance

Customer: Dart Aerospace Ltd.
Customer Order Number: P0039230
Sales Order Number: 39513-1

Part Number: B80702-1	Description: Sleeve, Engine Mount
Drawing / Revision Level: A	Quantity: 12
Production Order: PR1800025612	Batch No.: PR1800025612
Part Number: B80703-1	Description: Stud, Male 7/8, Engine Mount
Drawing / Revision Level: A	Quantity: 4
Production Order: PR1800025612	Batch No.: 14-3187
Part Number: B80704-1	Description: Stud, Male, 3/4, Engine Mount
Drawing / Revision Level: A	Quantity: 8
Production Order: PR1400016026	Batch No.: 14-3186
Part Number: B80705-1	Description: Stud, Female, Engine Mount
Drawing / Revision Level: B	Quantity: 12
Production Order: PR1800025613	Batch No.: PR1800025613

B/E Aerospace Limited hereby certify that materials, work performed and quality meet the requirements stated on the Customer's Purchase Order(s) and/or drawing(s).

Notes / Comments:

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Condition - NEW

MAY 22 2018

Signature:

Name: Jeff Brien

Date: 2018 Apr 27

Form completed by: Jean Martin



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Power to Deliver.

Page 1 of 1

Certificate of Compliance

Customer: Dart Aerospace Ltd.
Customer Order Number: P0039230
Sales Order Number: 39513-1A

Part Number: B80702-1	Description: Sleeve, Engine Mount
Drawing / Revision Level: A	Quantity: 12
Production Order: PR1800025612	Batch No.: PR1800025612
Part Number: B80703-1	Description: Stud, Male 7/8, Engine Mount
Drawing / Revision Level: A	Quantity: 4
Production Order: PR1400016025	Batch No.: 14-3187
Part Number: B80704-1	Description: Stud, Male, 3/4, Engine Mount
Drawing / Revision Level: A	Quantity: 8
Production Order: PR1400016026	Batch No.: 14-3186
Part Number: B80705-1	Description: Stud, Female, Engine Mount
Drawing / Revision Level: B	Quantity: 12
Production Order: PR1800025613	Batch No.: PR1800025613

B/E Aerospace Limited here by certify that materials, work performed and quality meet the requirements stated on the Customer's Purchase Order(s) and/or drawing(s).

Notes / Comments:

DAS
11
9-89

Condition - NEW

This corrected certificate replaces the certificate 39513-1 dated 2018 Apr 27 and does not recertify conformity / condition or release to service.

Signature:

Name:

Marcie Hayag

Date: 2018 May 17

MAY 22 2018

Form completed by: Jean Martin



Passion to Innovate
Power to Deliver

Packing Slip

B/E Aerospace Limited

25 Dunlop Avenue

R2X 2V2 Winnipeg
Canada

Tel : 204-783-5402

Fax : 204-783-5436

Delivery No. : 8479
Delivery Date : 2018-04-26
SO No. : 39513
Your Reference : PO: PO039230
Delivery Method : FEDEX
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention: CHANTAL LAVOIE

1270 Aberdeen Street

Hawkesbury K6A 1K7

Canada

Item	Description Batch Number	Total Ordered	Unit	Qty Delivered	Delivery Date
B80702-1	SLEEVE, ENGINE MOUNT PR1800025612	12	EA	12	2018-04-26
B80703-1	STUD, MALE, 7/8, ENGINE MOUNT 14-3187	4	EA	4	2018-04-26
B80704-1	STUD, MALE, 3/4, ENGINE MOUNT 14-3186	8	EA	8	2018-04-26
B80705-1	STUD, FEMALE, ENGINE MOUNT PR1800025613	12	EA	12	2018-04-26
NAS509-12	NUT (.7500-16 UNJF-3B) 13-1954	12	EA	12	2018-04-26
NAS509-L12	NUT STEEL (.7500-16 UNJF-3B-LH) LH THREAD 13-2349	12	EA	12	2018-04-26

MAY 22 2018

DAS
11
2018

Ordered by: Dart Aerospace Ltd.

Attention: CHANTAL LAVOIE

1270 Aberdeen Street

Hawkesbury K6A 1K7

Canada

Invoice to: Dart Aerospace Ltd.

Attention: Accounts

1270 Aberdeen Street

Hawkesbury K6A 1K7

Canada

Remarks

I hereby certify that the aircraft part(s) described hereon were
acquired from a source of supply that is consistent with the
conditions under which TCCA distributor approval AMO88-97
has been granted.

Signatory

Date:

27 APR 2018

71.4 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D205-708-011	ADJUSTABLE ENGINE MOUNT KIT (205/UH-1)
	X	D204-708-013	ADJUSTABLE ENGINE MOUNT KIT (204)
6	6	D3284-001	SLEEVE
2		D3284-003	STUD
4	6	D3284-005	STUD
6	6	D3284-007	STUD
6	6	D3284-009	BEARING
1	1	D3284-011	BEARING
2	2	MS20613-6C12	RIVET
8	12	MS20613-6C16	RIVET
4		MS20613-6C18	RIVET
12	12	MS20613-6C19	RIVET
6	6	NAS509-12	NUT
6	6	NAS509L12	NUT

71.5 WEIGHT AND BALANCE

The following is the net weight and moment change associated with this installation

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-708-011 Adjustable Engine Mount Kit (205/UH-1)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	188.5 in 4.79 m	1810 lb-in 21.1 kg-m
D204-708-013 Adjustable Engine Mount Kit (204)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	184.5 in 4.69 m	1771 lb-in 20.6 kg-m